

Date: Monday, 16/03/2009 2:01:39 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MAINTENANCE STEP, RH
<b>Job Number</b> : 46525	
<b>Estimate Number</b> : 11284	
<b>P.O. Number</b> :	<b>Part Number</b> : D3436044
<b>This Issue</b> : 16/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3436 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44580	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 06/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JULIA 03-16</u>	
<b>Comment</b> : EsT A 05.05.11 New Issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34361

Clamp



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1 D3436-1 Clamp

B44785EL 9-4-7

2.0

D34364

Right Step



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

RH Step

Pick:

Qty Part Number Description Batch

1 D3436-4 LH Step

B46591EL 9-4-7

3.0

D34365

Bushing



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

4 D3436-5 Bushing

B34035 23357EL 9-4-7

4.0

D34367

Cap



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

1 D3436-7 Cap

B42323EL 9-4-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, RH

Job Number: 46525

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev:

A

Qty	Part Number	Description	Batch
A/R/N/A	4130	Welding Rod	M100075

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/R/N/A	4130	Welding Rod	M100075

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/R/N/A	4130	Welding Rod	M100075

(HX)

SP 09.04.8.

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

1-Slit part D3436-041 on bandsaw as per Dwg D3436  
2- deburr

(HX)

SP 09.04.8

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 09.04.08 (HX)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09.04.08 (HX)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4 -- m11013

START TIME: 6:15  
OVEN TEMPERATURE: 400°  
FINISH TIME: 6:45

FL 09/04/09 (4)

FL 09/04/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, RH

Job Number: 46525

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pl 09-04-9 (4)

11.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty Part Number Description

2 D3436-9 Pad

A/R N/A Contact Cement

Batch  
B924/4  
M109/09

8/09/04/15 (4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/04/15 (4) RHC

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 203

9/14/15

(4)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



mf  
09-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

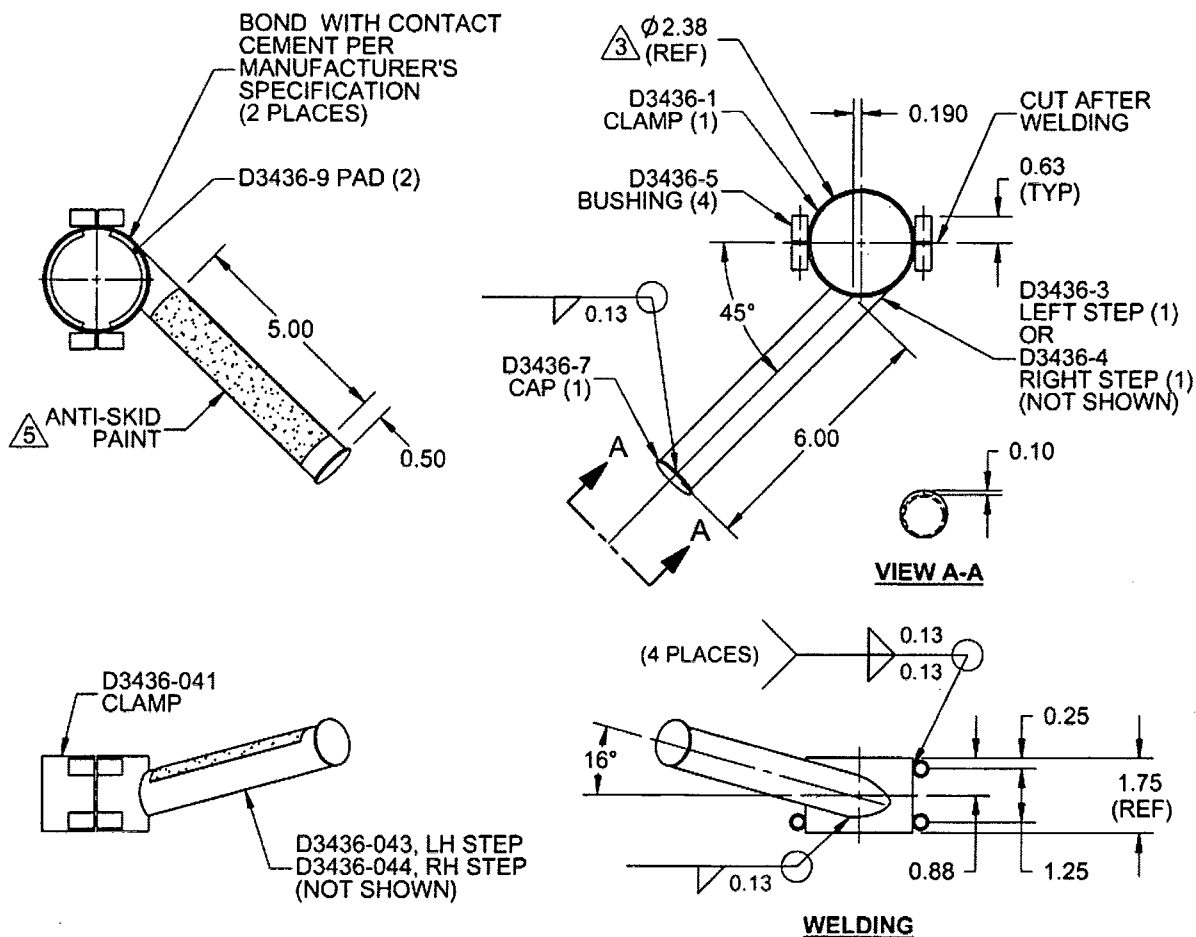
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:4
A	05.04.28	NEW ISSUE	



**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.05.27 *[Signature]*

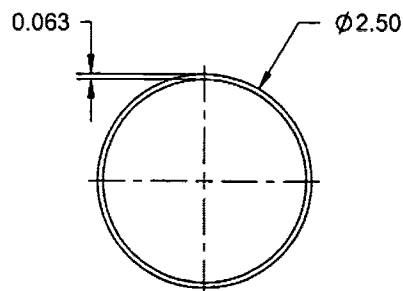
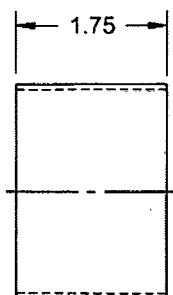
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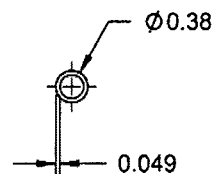
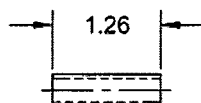


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DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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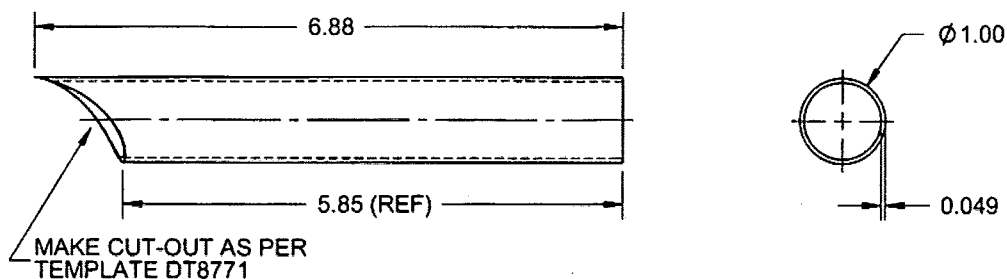
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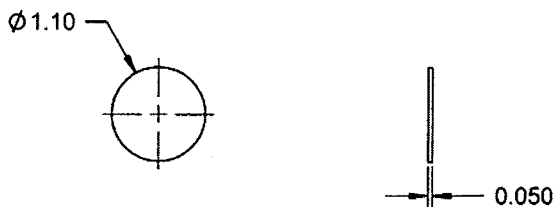
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DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2



### **D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



### **D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

### **D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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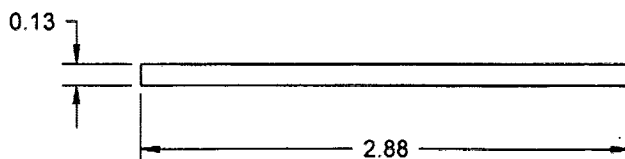
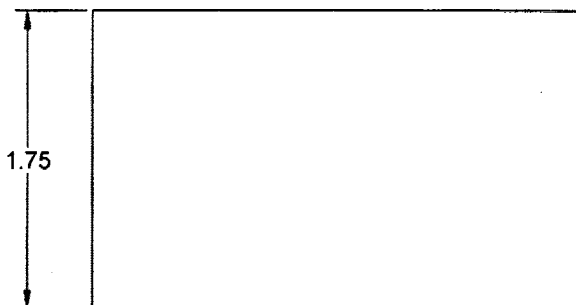
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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:1



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05.05.27 *[Signature]*

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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